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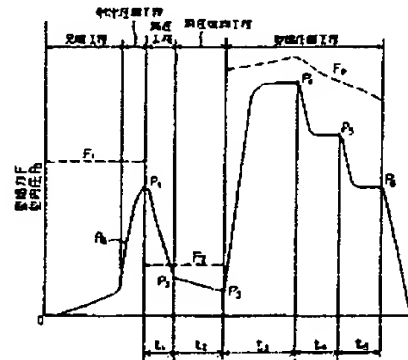
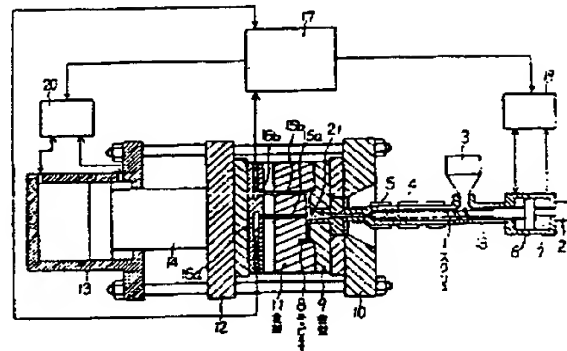
APPLICATION DATE : 17-07-85
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APPLICANT : CHURYO ENG KK;

INVENTOR : TSURUMAKI MASA;

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TITLE : INJECTION MOLDING PROCESS



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ABSTRACT : PURPOSE: To make the photocharacteristic of a molded product to be excellent, removing its residual stress-fracture, warpage and deformation by a method in which the incline of the inner pressure of a mold in the flow direction of a molded product before the process of mold clamping/compressing, is omitted, and the mold clamping/compressing is further precisely multistage-controlled.

CONSTITUTION: To equalize the amount of injected resin of every shot when the inner pressure P_a of a mold (near a gate) obtained by a sensor 16a reaches injecting compressive pressure P_1 (filling pressure in the mold plus compressive pressure) having been preliminarily set, a screw 1 is retreated and the inner pressure is reduced to P_2 from P_1 . After that, the inner pressure P_a of the mold is regulated to P_3 by the fine advance and retreat of the screw correspondingly to the change of the inner pressure P_b (the end of resin blow) of the mold obtained by the sensor 16. Its regulation time is controlled with the fine regulation timer t_2 for pressure reducing constant. Then, the process is advanced to the compression caused by mold clamping pressure, and the detected inner pressure P_a of the mold is compared with preliminarily set values P_4 , P_5 , P_6 , thereby operating the control mechanism 20 for mold clamping, and controlling the mold clamping process by a closed loop.

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